

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012065**Date Inspected:** 05-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Zhong An, Du Zhi Qun			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Tower	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10 TOWER STRUT

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ND1-STSA3-1-109M-1-9, 10, 11, 12, 25, 26A/B GREEN TAG NO. 11715

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10**SOUTH TOWER LIFT 5 C/D CORNER SEAM**

SMAW welding of weld joint 17A located on SSD1-TL5-1B-F.

Welder is identified as 050289. ZPMC CWI is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U4b-1.

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SOUTH TOWER LIFT 5 D/E CORNER SEAM

SMAW welding of weld joint 24A located on SSD1-TL5-1B-F.

Welder is identified as 052930. ZPMC CWI is identified as Mr. Du Zhi Qun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U4b-1.

NORTH TOWER LIFT 5 GRILLAGE BEAM REPAIR

SMAW welding of weld joint 4A/B(Repair) located on ND1-BPSA5-3.

Welder is identified as 057258. ZPMC CWI is identified as Mr. Liu Zhong An .

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-REPAIR-1.

TOWER STRUT ANGLE CONNECTION PLATE (T-CWR561, REV. 0)

During random in process verification, this QA Inspector observed that SMAW welding on the base metal of ED1-SA3-18-99M-1 of Tower Strut Angle Connection plate. Welder is identified as 040268. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-FCM-REPAIR-1. Attached photographs provide additional details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer